

Date: Friday, 10/10/2008 12:52:04 PM
 User: Julie Lécocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSY (RH)
Job Number : 42535	
Estimate Number : 13286	
P.O. Number :	Part Number : D3699042
This Issue : 10/10/2008 S.O. No. :	Drawing Number : D3699 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 41020	Material :
Written By :	Due Date : 31/10/2008 Qty: 2 Um: Each
Checked & Approved By : JLD 08.10.10	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.4797 sf(s)/Unit Total: 0.9595 sf(s)

6061T6 aluminium sheet .050" thick

(M6061T6S050)

Batch: 104186

HB 8-10-27
 HB 8-10-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3699

Dwg Rev: A

Prog Rev: A

***grain direction along 9.00" ***

2- Deburr if necessary

HB 8-10-27

HB 8-10-14

HB 8-10-14

HB 8-10-27

(2)

(4)

HB 8-10-27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-10-14

HB 8-10-27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/10/14 (2)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg D3697

SB 08/10/23

(4)

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/10/2008 12:52:04 PM
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Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/10/23 (X2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

(P12)

1- counter sink holes as per dwg D3699

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/10/28 (5)

808/10/28 (X5)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/10/28

(SX)

10.0

POWDER COATING

POWDER COATING



M 10 S 642



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20
3:20
7:50

M-1 08/10/31

(SX)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F-2 08/10/31

(5)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut Plate

batch:

M107479

85 08/10/31 (X5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3699-042 PAR #: N/A Fault Category: Prod - Sm. Red. NCR: Yes No DQA: HA Date: 08/11/18
 (D412-776-041) Resolution: Scrap Disposition: Scrap QA: N/C Closed: HA Date: 08/11/20

NCR: 42535		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/27	#7.0	employee noticed after counter sinking the first hole that it was on the wrong side.	08/10/27	Scrap and Destroy and Replace Qty (10)	08/10/27	08/10/27	08/10/27	08/10/27
		Rel employee wasn't paying attention to Dwg.	08/10/27	164186 (14) Bend as per Dwg. Qty of (5)	08/10/27	08/10/27	08/10/27	08/10/27

NOTE: Date & initial all entries

Date: Friday, 10/10/2008 12:52:04 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 42535

Part Number: D3699042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10 4.0000 Each(s)

Rivet

batch:

M1563

JS 08/10/31 x5

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

Ed 08/11/03 (5)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08-11-03 (5)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

184

JS 11/13

(54)

SL

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/04 JS

Job Completion



U 08.11.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

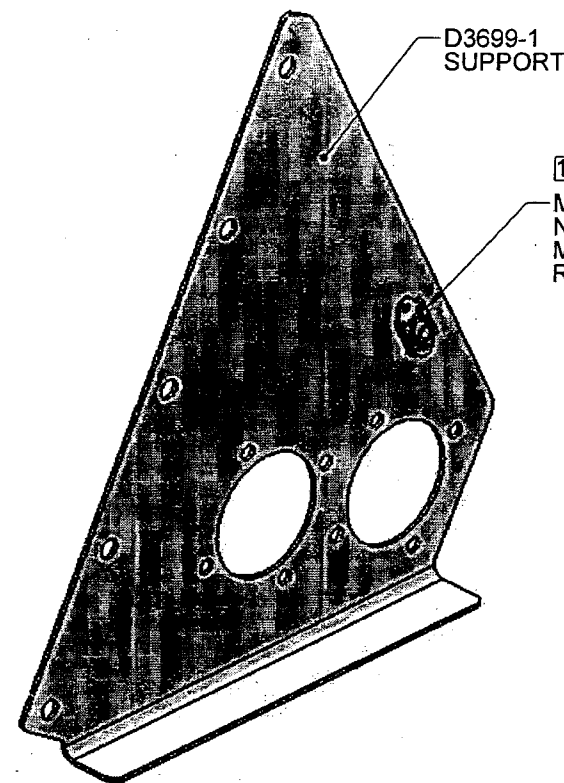
DART AEROSPACE LTD		Work Order: 42535
Description: Support, RH		Part Number: D3699-2
Inspection Dwg: D3699	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

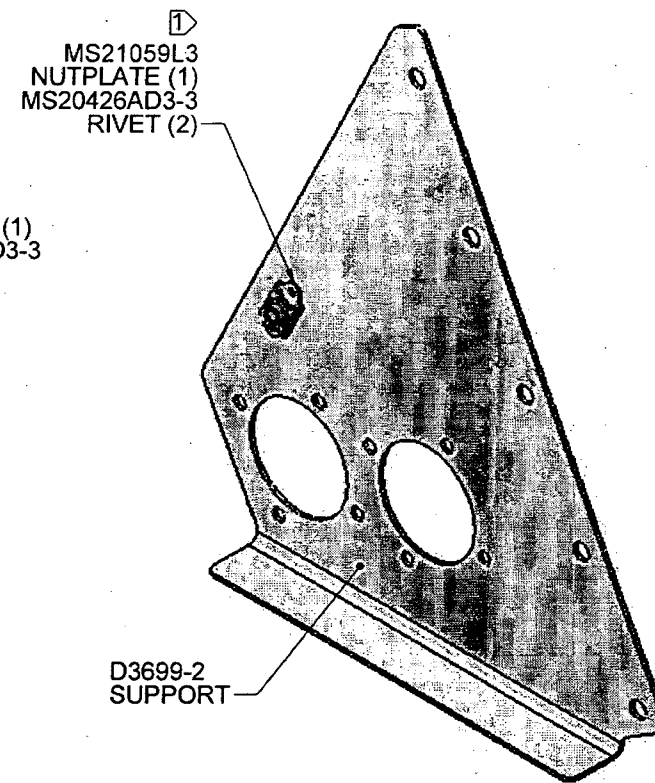
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	X			
Ø0.180	+0.005/-0.001	.180	X			
Ø0.238	+0.005/-0.001	.238	X			
Ø1.525	+0.012/-0.001	1.530	X			
0.36	+/-0.030	.368	X			
0.62	+/-0.030	.624	X			
0.96	+/-0.030	.961	X			
2.21	+/-0.030	2.213	X			
4.12	+/-0.030	4.120	X			
8.95	+/-0.030	8.95	X			
1.925	+/-0.010	1.928	X			
8.61	+/-0.030	8.61	X			
2.62	+/-0.030	2.622	X			
0.344	+/-0.010	.344	X			
0.688	+/-0.010	.691	X			
0.64	+/-0.030	.660	X			
2.66	+/-0.030	2.66	X			
5.75	+/-0.030	5.760	X			
6.41	+/-0.030	6.43	X			
0.300	+/-0.010	.304	X			
0.923	+/-0.010	.925	X			
0.050	+/-0.010	.050	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8-10-14	Date: 08/10/14	Date:	N/A
Rev	Date	Change	Revised by
A	08.09.04	New Issue	KJ/DD
			Approved



D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42535

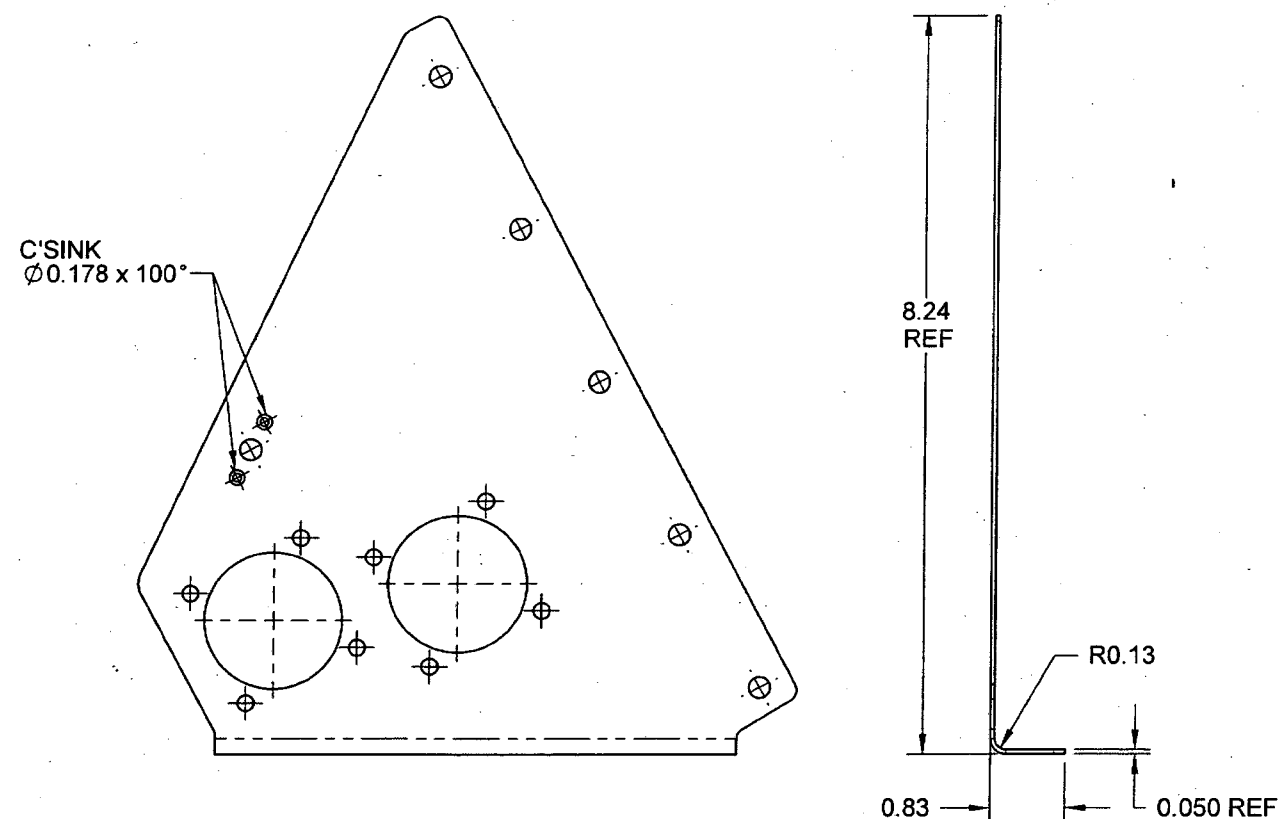
RELEASED
08.07.12

- NOTES:**
 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\phi 0.098$ HOLES ON D3699-1/-2
 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
 3) WEIGHT: 0.17 lb EACH

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	MA	D3699	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

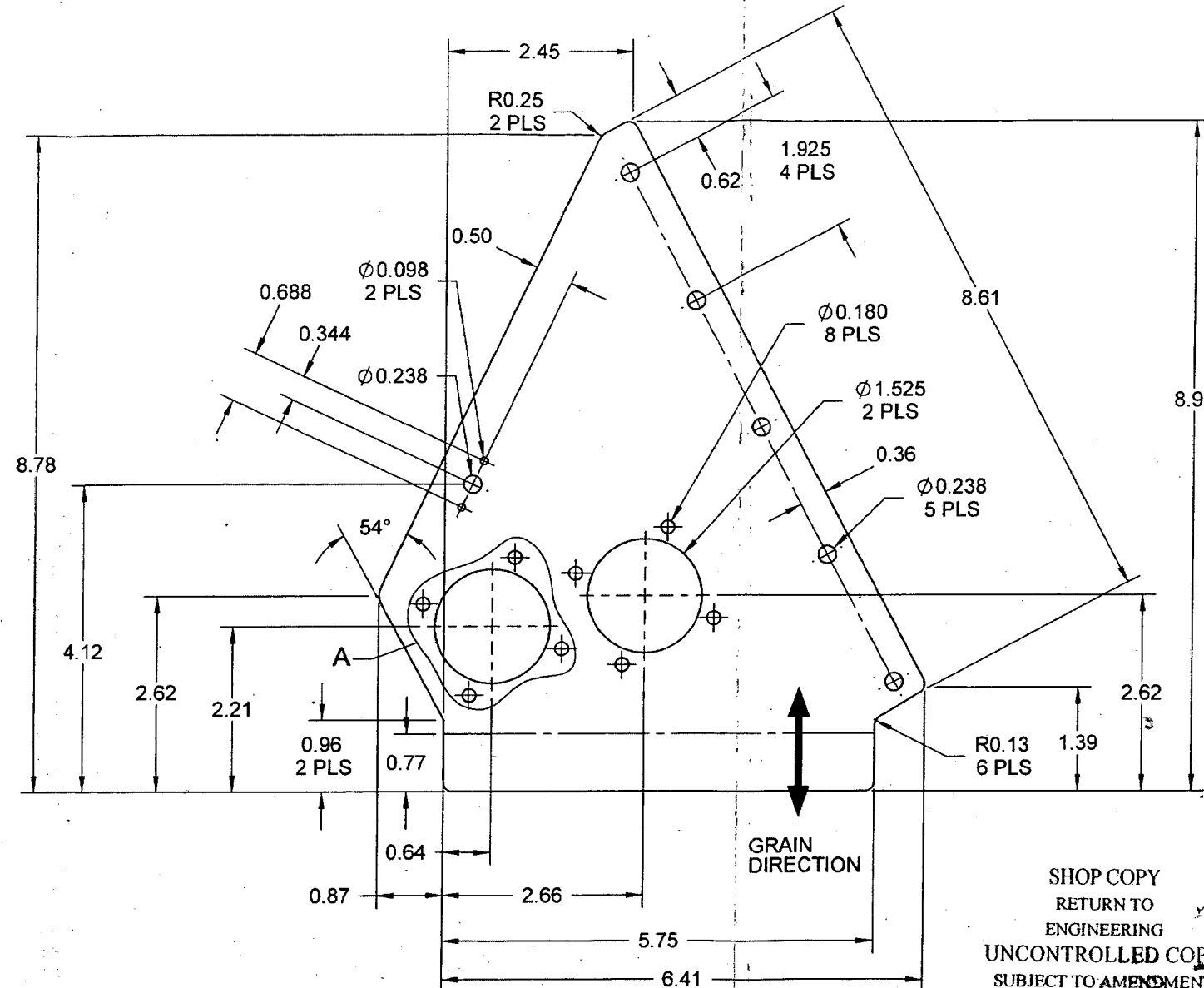
D3699-1 LH SUPPORT

D3699-2 RH SUPPORT



**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**

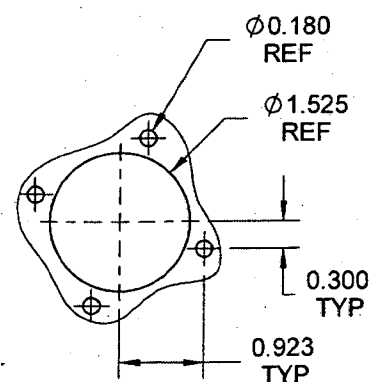
- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs



D3699-1F FLAT PATTERN

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42535

RELEASED
08-07-08 MP



DETAIL A

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
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DART AEROSPACE LTD	Work Order: 42535
Description: SUPPORT	Part Number: D3699-2
Inspection Dwg: D3699-2, Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .180	+ .005 - .001	.183	X			
Ø .238	+ .005 - .001	.240	X			
Ø 1.525	+ .012 - .001	1.529	X			
.36	+/- .030	.368	X			
.62	+/- .030	.624	X			
.96	+/- .030	.961	X			
2.21	+/- .030	2.213	X			
4.12	+/- .030	4.120	X			
8.95	+/- .030	8.95	X			
1.925	+/- .010	1.928	X			
8.61	+/- .030	8.61	X			
2.62	+/- .030	2.622	X			
.344	+/- .010	.344	X			
.688	+/- .010	.691	X			
.64	+/- .030	.66	X			
2.66	+/- .030	2.66	X			
5.75	+/- .030	5.760	X			
6.41	+/- .030	6.43	X			
.300	+/- .010	.304	X			
.923	+/- .010	.925	X			
.050	+/- .010	.050	X			

Measured by: JB
Date: 8-10-27

Audited by: S
Date: 08/10/27

Prototype Approval: n/A
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	